

Date: Thursday, 5/4/2006 11:10:05 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : REPLACEMENT WINDOW ASSEMBLY
Job Number : 26932	
Estimate Number : 11174	
P.O. Number : <i>N/A</i>	Part Number : D3290041
This Issue : 5/4/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3290 REV <i>AB</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : <i>AB 20606.13</i>
Previous Run : 26454	Material : <i>N/A</i>
Written By : <i>SEE COMMENT BELOW</i>	Due Date : 5/18/2006 Qty: <i>17</i> Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est. B 05.05.25 Added Step 11 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O:

Manufacture D3290-1 as per Dwg D3290

Possible Supplier: GFI

Material release note is required

5052-H3A

0.040" thick

300 SF

batch:

2.0

D32901F

D32901F

Window Frame

P/O # 1249

C206105115 (20)



Comment: Qty.: 1.0000 U(s)/Unit Total : 6.0000 U(s)

Replacement Window Assy

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAN 06'06'05 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:10:05 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 26932

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/06/07

(20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/07

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JAD 06:06:08

(20)

9.0

D21260780

Locking Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Locking Seal

Pick:

Qty Part Number Description

Batch

1 D2126-0780 Locking Seal

B23698 0000 (1)

B23696 0000 (1)

B25702 (5)

10.0

D32901

Window Frame



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

Window Frame

Pick:

Qty Part Number Description

Batch

1 D3290-1 Window Frame

B2693285

B23004 (2)

11.0

D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Window

Pick:

Qty Part Number Description

Batch

1 D3290-3 Window

B27090

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/06/09	10	15 frames put in st (missing seal to complete)	<i>[Signature]</i>				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/06/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:10:05 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 26932

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

SAD 06:06:08

7

(PTO)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-06-08

7

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 571.6

clean: wrap in plastic
In a very clean, debris free area.

06/06/07

(7)

7

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/07

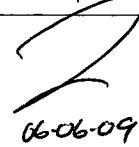
(7)

Job Completion



06-06-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-06-08	12	clean: wrap A + step 14 as stated, in a clean: debris free department. Remnant change.					 06-06-09

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

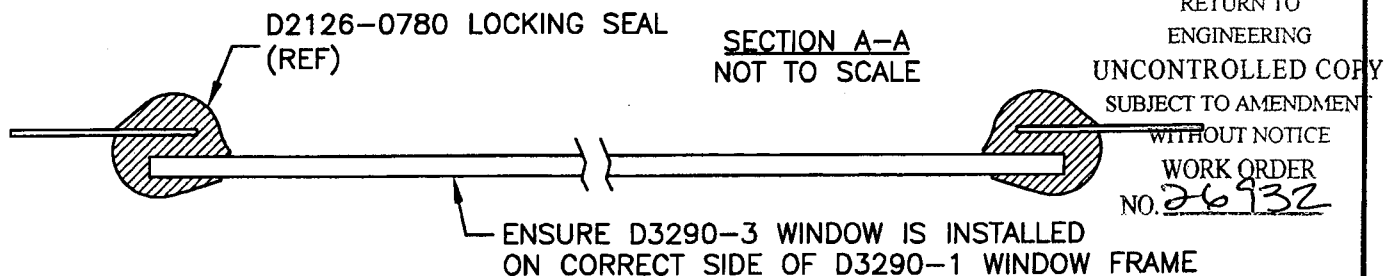
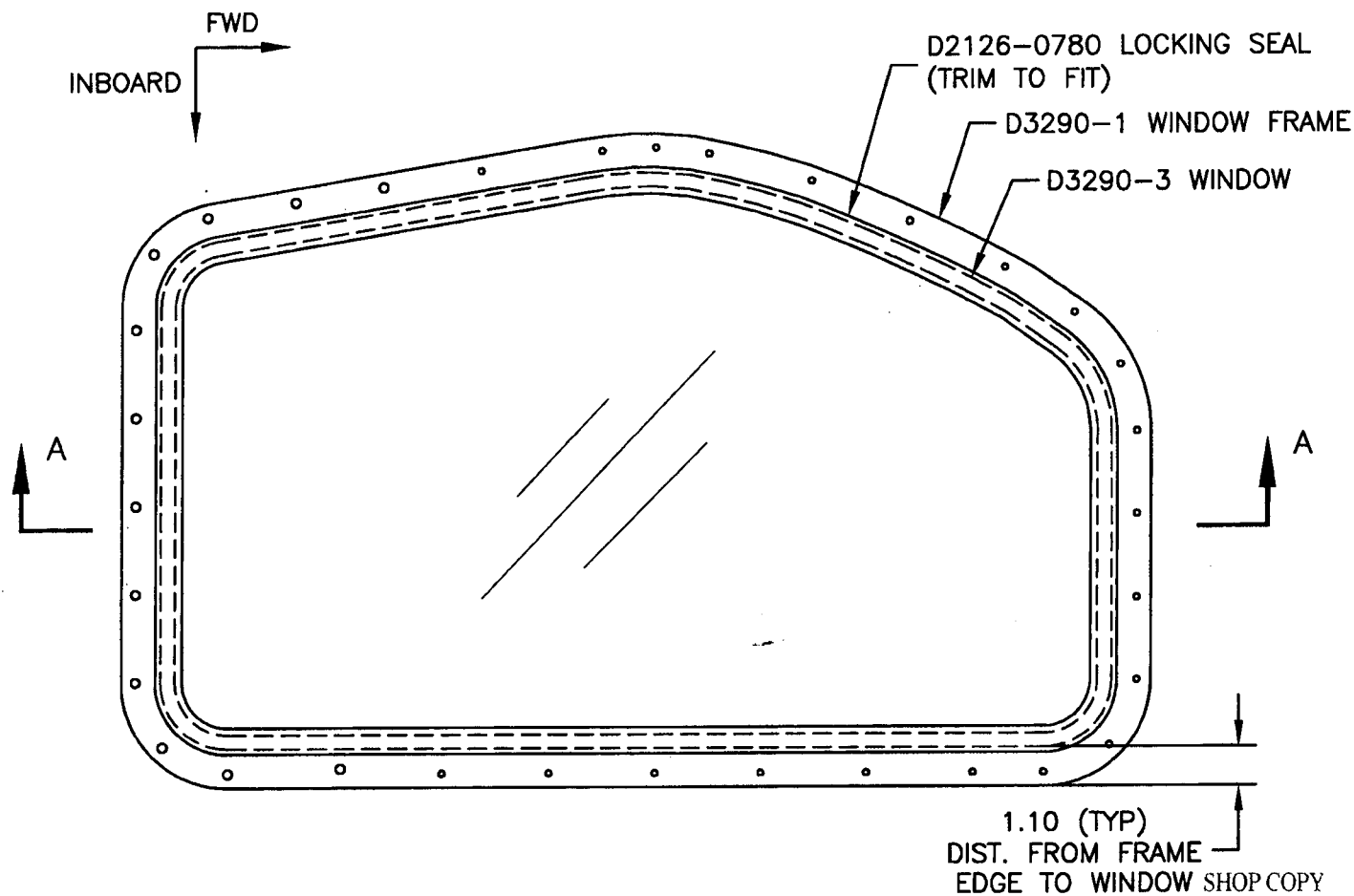
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 1 OF 3
DATE 06.04.20		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5
A	04.06.14	NEW ISSUE	
B	06.04.20	UPDATE MATERIAL PER NCR 029	



D3290-041

NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

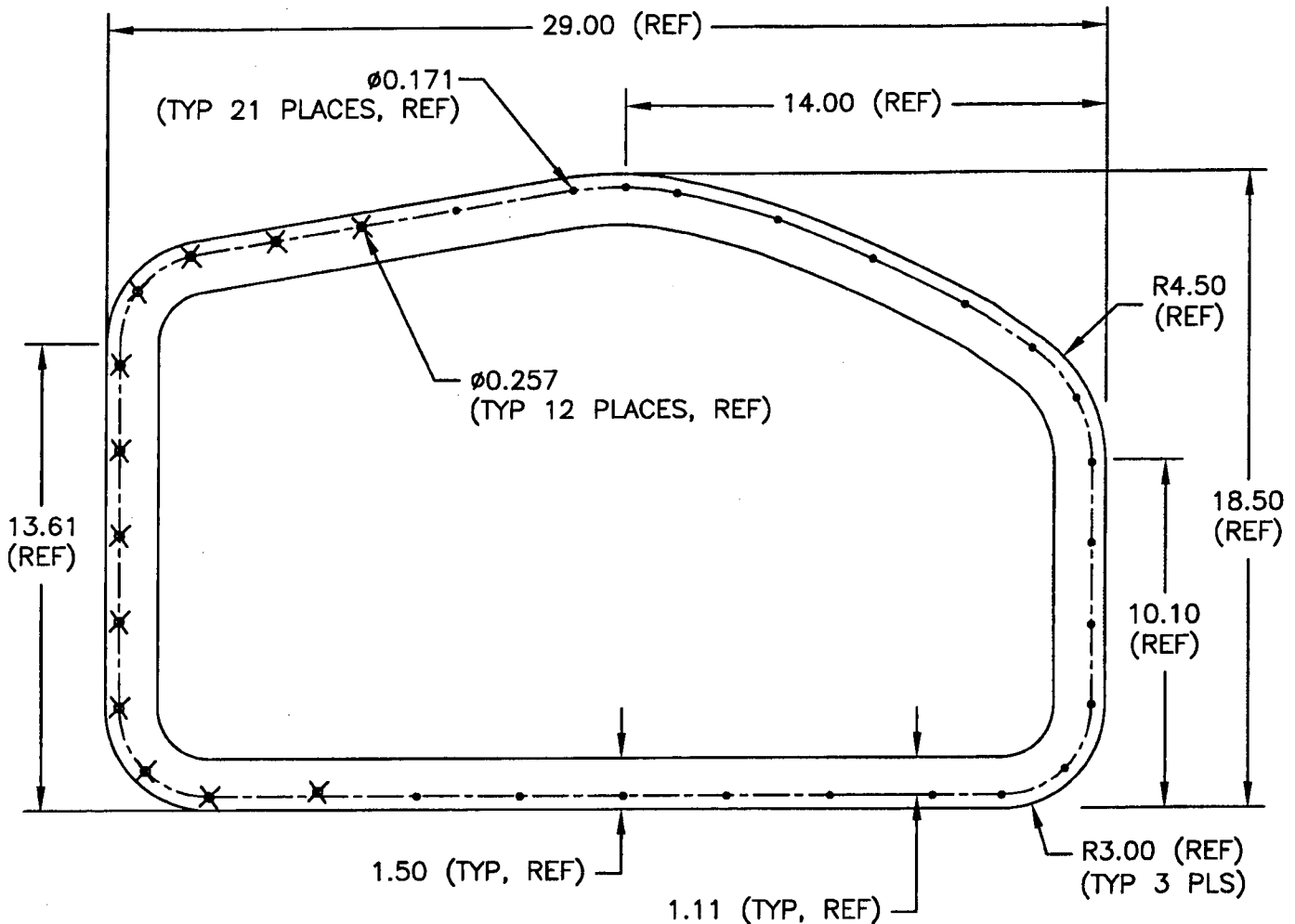
RELEASED
06.04.20 *[Signature]*

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 2 OF 3
DATE 06.04.20	TITLE REPLACEMENT WINDOW ASSEMBLY		SCALE 1:5

**D3290-1 FRAME****D3290-1**

- 1) MACHINE PER DRAWING FILE "D3290-A2.DWG"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) SHEET 0.040 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

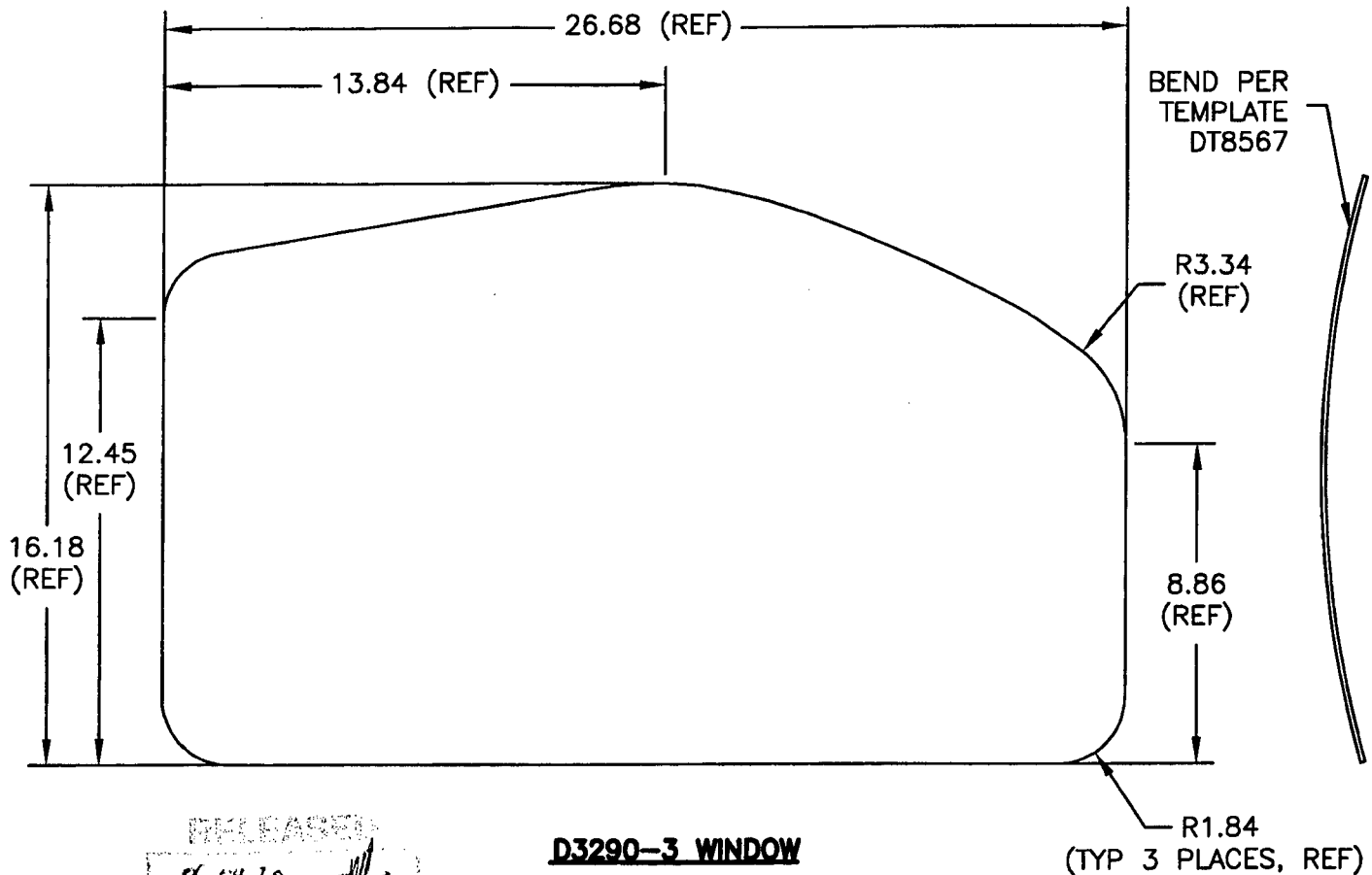
RELEASED
06.04.20
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WITHOUT NOTICE
WORK ORDER
NO. 26932

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DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. B SHEET 3 OF 3
DATE 06.04.20	TITLE REPLACEMENT WINDOW ASSEMBLY		SCALE 1:5



RELEASED
06.04.20 *[Signature]*

D3290-3
B

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) CHECK PART USING DT3290-3T1

SHOP COPY
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180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO
2006/05/30	0338152

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VENDU À / SOLD TO

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO	N° COMMANDE PO/NO	VIA SHIP VIA
DART GFI-0299		J0143533	PO00001249	
QUANTITÉ QUANTITY	VOIRE N° DE PIÈCE YOUR PART NO	DESCRIPTION		
20	D32001F see attached	WINDOW FRAME		

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

Division de / Division of ~~Thomas & Betts~~

GFI Inc.
100 Avenue Labrosse
Pointe-Claire, Québec
Canada H8P 1A7
Tel: (514) 630-4877
Fax: (514) 630-4849

NO. DU BON DE COMMANDE:
PURCHASE ORDER NUMBER:

P000001249

NO. DE LA PIÈCE:
PART NUMBER:

D32901F

DESCRIPTION:

WINDOW FRAME

QUANTITÉ:
QUANTITY:

20

BORDEREAU D'EMBALLAGE:
PACKING SLIP NUMBER:

338152

DATE:

MAY 30/06

CERTIFICAT DE CONFORMITÉ / CERTIFICATE OF CONFORMANCEATTENTION: INSPECTION À LA RÉCEPTION / RECEIVING INSPECTION

Le soussigné certifie que le matériel fourni et les pièces qui ont été achetées et expédiées selon le Bon de Commande portant le numéro mentionné ci-dessus et selon le bordereau d'emballage, sont conformes aux spécifications contractuelles applicables, aux exigences du Bon de Commande et de celles des dessins applicables. Les rapports applicables à ces commandes sont gardés en filières et peuvent être fournis sur demande.

The undersigned hereby certifies that the material and the items purchased and shipped herewith under the above purchase order and on the packing slip are in conformance with all the contractual applicable specifications, purchase order requirements and drawing requirements and reports are on file and will be made available upon request.

Division of Thomas & Betts

Département de contrôle de la qualité
Quality Control Department

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 1 OUR JOB NO J0143533 SHIPPING MEMO 0338152

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
--	20 PCS	PO00001249	D3290-1		WINDOW FRAME	B

MATERIAL	SUPPLIED BY	MAT. REL. NO.
AL 5052-H32	SAMUEL SPECIALTY / ORMET	D365146-004 ATT'D

	PROCESS	PROCESSOR	RELEASE NOTE #
1			
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 30 MAY 2006

G.F.I. Q.C. REP. B. Samei



342-06

LES MÉTAUX SPÉCIALISÉS SAMUEL

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ --LETTER OF COMPLIANCE

Date: 23 MAI 2006

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0060414
Customer's order #:

de commande SSMQ: 855252
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Gauge/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
2	4	.040" X 48" X 96"	5052 H32		D365146-004

Bien à vous,
Yours truly,



Wesley Gifford

Commis à l'administration.
Administration Clerk.

LES MÉTAUX SPÉCIALISÉS SAMUEL, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5
SAMUEL SPECIALITY METALS, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5

TÉL: 514-457-3399
FAX: 514-457-9393

LET. DE. COM 12/01/06



OR 1902

Must be electronically approved

CERTIFICATION OF INSPECTION & TEST RESULT**SOLD TO:**SAMUEL, SON & CO. LIMITED
2225 FRANCIS HUGHES
LAVAL QC H7S 1 N5**SHIP TO:**SAMUEL, SON & CO. LIMITED
900 CUNARD
LAVAL QC H7S 2 H6ORDER NUMBER
005619800B/L #
R047719SHIPPING POINT
FDSHIP DATE
10/10/2005TYPE CERTS
N/APURCHASE ORDER NUMBER
C58523 PREBILLCARRIER
TRANSPORT PEREZ

ITEM	DESCRIPTION	TENSILE KSI		YIELD KSI		% ELONGATION	
		MIN	MAX	MIN	MAX	MIN	MAX
001-01	5052 H32 00.04000 48.0000 MF-CS VMN	33.1	33.8	26.1	27.1	11	14

PART NO. CD5052040048800

LOT TICKET D365146-004

SPECIFICATIONS

AMS-QQ-A-250-8A
(9/98)
ASTM B209 (5/2001)WEIGHT Lbs
6,664



OR 1902

Must be electronically approved

CERTIFICATION OF INSPECTION & TEST RESULT

SOLD TO: SAMUEL, SON & CO. LIMITED 2225 FRANCIS HUGHES LAVAL QC H7S 1 N5		SHIP TO: SAMUEL, SON & CO. LIMITED 900 CUNARD LAVAL QC H7S 2 H6		
ORDER NUMBER	B/L #	SHIPPING POINT	SHIP DATE	TYPE CERTS
005619800	R047719	FD	10/10/2005	N/A
PURCHASE ORDER NUMBER		CARRIER		
C58523 PREBILL		TRANSPORT PEREZ		

Actual Chemistry

Chemical Composition Limits of Wrought Aluminium Alloy

LOT TICKET	SI	FE	CU	MN	MG	CR	ZN	TI	OTHERS		AL
									EACH	TOTAL	
D365146-004	0.10	0.30	0.02	0.04	2.2	0.16	0.02	0.03	..		Rem

5052

CERTIFICATION OF INSPECTION AND TEST RESULTS

"Ormet Aluminum Mill Products Corporation certifies that the material used in the fabrication of this order has been inspected and tested and found to be in conformance with the requirements of applicable specifications shown in the item description indicated herein. Test reports for this material are on file subject to examination."

"No aluminum produced by Ormet Aluminum Mill Products Corporation contains concentrations of heavy metals (lead, mercury, cadmium and hexavalent chromium) greater than the trace amounts allowed by governmental regulation, CONEG recommendations, and are in compliance with the state of California's Safe Drinking Water and Toxic Enforcement Act ("Proposition 65") restrictions on "known carcinogens and reproductive toxins". There are no Proposition 65 listed chemicals present at concentrations that exceed the established no observable effects levels (NOEL) for reproductive toxicants or significant risk levels for carcinogens. No greenhouse ozone depleting gases or materials contaminated with asbestos, hazardous waste or radioactivity are used for the production of metal."

"This certification shall be deemed a part of and subject to all the Terms and Conditions set forth on the front and reverse sides of Ormet Aluminum and/or order Acknowledgment forms."

BY:

CERTIFYING AUTHORITY